

Date: Monday, 7/9/2007 11:46:44 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 SKIDTUBE "I" BEAM
Job Number	: 33348		
Estimate Number	: 10346		
P.O. Number	: <i>N/A</i>	Part Number	: D2596
This Issue	: 7/9/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2596 REV <i>ED</i>
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 33058	Drawing Revision	: <i>ED</i>
		Material	: <i>N/A</i>
		Due Date	: 7/13/2007
Written By	: <i>[Signature]</i>	Qty:	4 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D		
	M		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D25003100	Ext'n -I' Beam Web 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Extrusion "I" Beam Web 4"

Pick;

Qty	Part Number	Description	Batch
1	D2500-3-100	Extrusion	<i>B31223</i>

77-16

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

77-16

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Acid Etch and Alodine per QSI 005 4.1

77-16

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

DP 77-17 *(4)*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *4/6*

DP 77-17

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:46:44 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 33348

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

D 07.07.18

Job Completion



U 07.07.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

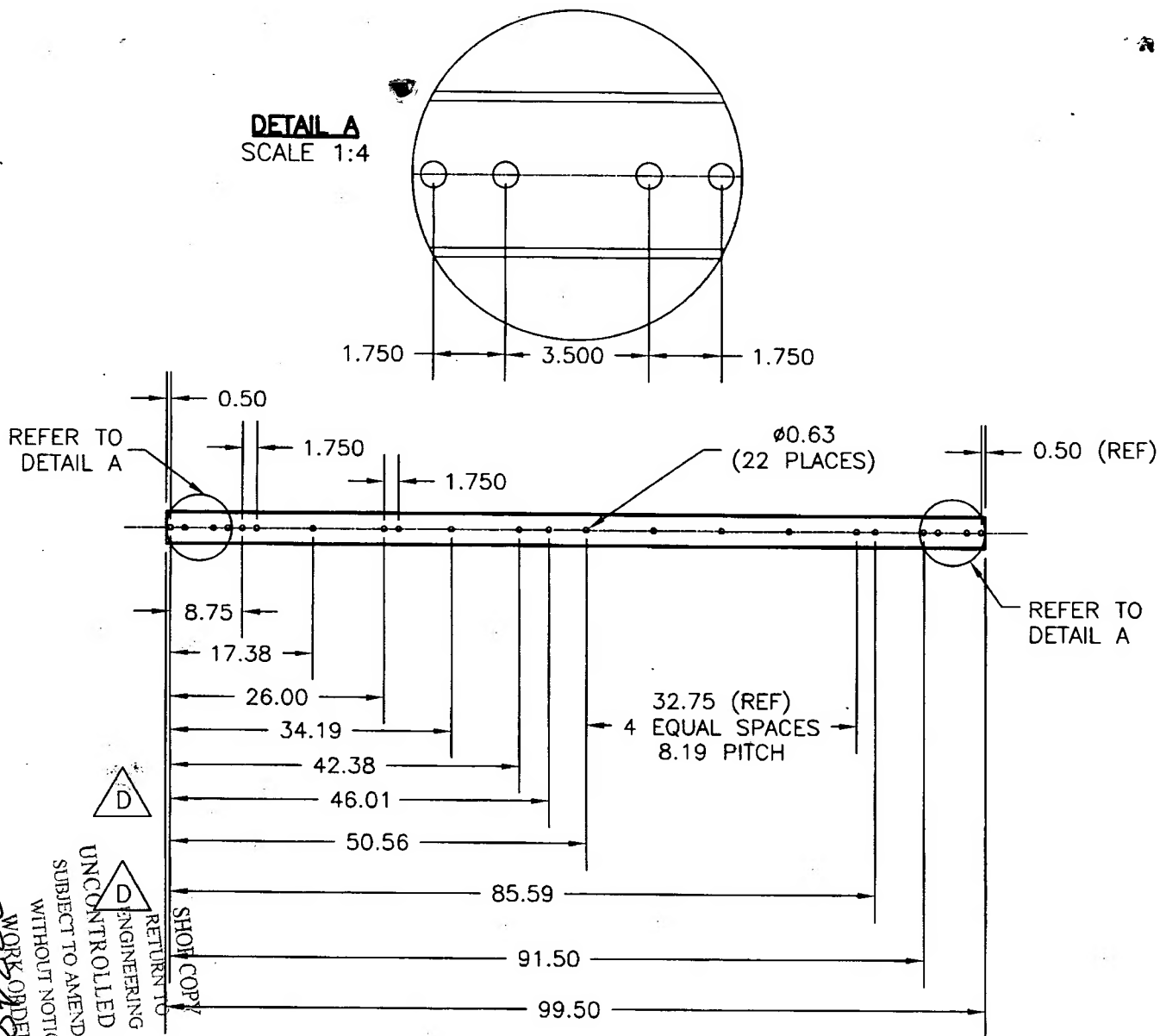
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07.06.68

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. D
04	04	DRAWING NO.	D2596	SHEET 1 OF 1
CHECKED	APPROVED	DATE	TITLE	SCALE
07.04.17	07.04.17	205 WEB	205 WEB	1:20
A	96.09.16	NEW ISSUE		
B	97.07.23	Ø0.63 HOLE WAS Ø0.56		
C	98.09.14	INCORPORATED DEO 9097		
D	07.04.17	INCORPORATED DEO 9183		

DETAIL A
SCALE 1:4

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

SHOH COPY
RETURN TO
ENGINEERING

D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

DART AEROSPACE LTD		Work Order: <u> </u>
Description: Boorpow 205 web		Part Number: D2596
Inspection Dwg: D2596 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.50	±0.03	0.50	✓			
B 1.750	±0.001	1.750	✓			
C 1.750	±0.001	1.750	✓			
D 0.50 (REF)	±0.03	0.470	✓			
E 8.75	±0.03	8.75	✓			
F 17.38	± "	17.38	✓			
G 26.00	± "	26.00	✓			
H 34.19	± "	34.19	✓			
I 42.38	± "	42.38	✓			
J 46.01	± "	46.01	✓			
K 50.56	± "	50.56	✓			
L 32.75	± "	32.75	✓			
M 8.19	± "	8.19	✓			
N 85.59	± "	85.59	✓			
O 91.50	± "	91.50	✓			
P 99.50	± "	99.50	✓			
Detail A						
1.750	±0.001	1.750	✓			
3.500	± "	3.500	✓			
1.750	± "	1.750	✓			

Measured by: DP	Audited by: RL	Prototype Approval: N/A
Date: 7-7-12	Date: 07.07.12	Date: N/A
Rev: A Date: 04.01.09 Change: New Issue	Revised by: KJ/RF	Approved:

$\frac{1}{2} \times \frac{1}{2} = \frac{1}{4}$